

**Work Order ID 58326**

Monday, May 03, 2010 11:43:53 AM



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*mf*

Date:

*10-5-3*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3915

B

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *m112860* 0.00  
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D3915

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*1 p**BE 10-05-06**1 0 BE 10/05/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 5/3/2010 Start Qty: 1.00

Required Date: 5/14/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/06/06



130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M 10/05/07



✓ \*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

140

Weld per dwg A/R Aluminum rod Batch: <sup>M112860</sup> ~~M4462~~

0.00



Large Fab

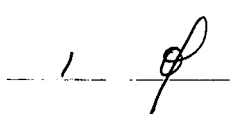
Memo

0.00

Large Fab

1- weld (4) corners

M 10.05.10



W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.05.10

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

\*\*\*inspect fit of lid with base\*\*\*

8 10/06/09

@

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners  
\*\*\*do not acid etch\*\*\*

10/06/09

1 9

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

- ✓ 1- touch up corner with alodine only
- ✓ 2- Plug holes prior to

11114841

1ST COAT:

START TIME: 10:15am

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:45am

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 11:15am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:45am

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

ml 11 06 09 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



[illegible]

Page 5



[REDACTED]

████████████████████

[illegible][illegible][illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Insp. Stamp

**RESEARCH**

## Hand Finishing

2- Install placard and label as per dwg

[illegible]

0.00

## Quality Control

0.00

[illegible]

## Memo

### Packaging

W/O:		WORK ORDER CHANGES					
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Required Date: 5/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15 JF

MF

10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 03, 2010 11:43:53 AM

Page 1

Work Order ID: 58326

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/3/2010

Required Date: 5/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:B add realodine DD  
10.04.26 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2728-1		Manufactured	No			180	Each	0.0000	1		5/3/10	①
Dart Logo label												
D2957		Manufactured	No			100	Each	15.0000	4		10.05.06	
Mounting Plate												
<div> <div>Location</div> <div>WA</div> <div>57697</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
D3915-1		Manufactured	No			100	Each	0.0000	2		10.05.06	358303
Rib												
D4016-5		Manufactured	No			100	Each	12.0000	3		10.05.06	
Hinge Half, Light Lid												
<div> <div>Location</div> <div>ENG</div> <div>56075</div> <div>ST109</div> <div>57293</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>												
D4019-3		Manufactured	No			100	Each	0.0000	3		10.05.06	358305
Rib												
D4029-041		Manufactured	No			180	Each	2.0000	1			
Webbing (Long Basket)												

Location st503 56963

Loc Qty 2 2

Loc Code

358109 (12)

5/3/10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Parent Item Name:** Light Lid Assembly, Long Basket

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**Required Date:** 5/14/2010

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:B add realodine DD  
10.04.26 verified by:EC

**Start Qty: 1.00**

**Required Qty: 1.00**

Component Item ID/ Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route	Unit of Each	Qty on 0.0000	Qty per Kit 1	Qty	Date	Status
D4035-045 		No			100	Each	0.0000	1		K 10.05.05 B58306	
Lid Rib Assembly, Fwd (Light)											
D4035-047 	Manufactured	No			100	Each	0.0000	1		K 10.05.06 B58307	
Lid Rib Assembly, Aft (Light)											
D4056-1 	Manufactured	No			100	Each	2.0000	1		K 10.05.06 B58308	
Label Plate											
D4086-220 	Manufactured	No			180	Each	6.0000	1			
Placard, Max Load											
MS20600-AD4W3 	Purchased	No			180	Each	1,891.000	34		S 10/06/11 @	
Cherry Rivets											
			<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>		
			WA			2					
				56661		2					
			<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>		
			ST112			6					
				56979		6					
			<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>		
			ST321			1891					
				106375		3					
				107939		888					
				111636		1000					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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per dwg revB DD 10.04.20 verified by:EC IPP Rev:B add realodine DD  
10.04.26 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
NAS1149DN416J		Purchased	No			180	Each	270.0000	34			
Washer												

Location	Loc Qty	Loc Code
ST	4	
13910	4	
ST275	166	
114340	166	
ST298	100	
114348	100	

*EP 5/10/06/11*

*34*

AN5-21A

NAS 1149FO563P

MS21042L5

D 2535

D 2537

D 2530

AN3-20A

MS21042L3

M 16463

M 108471

M 114449

B 56385

B 58429

B 59154

M 1113845 105/25

M 114523

*qty 2*

*qty 2*

*qty 2*

*qty 2*

*qty 2*

*qty 1*

*qty 2*

*qty 2*

*EP 10/06/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

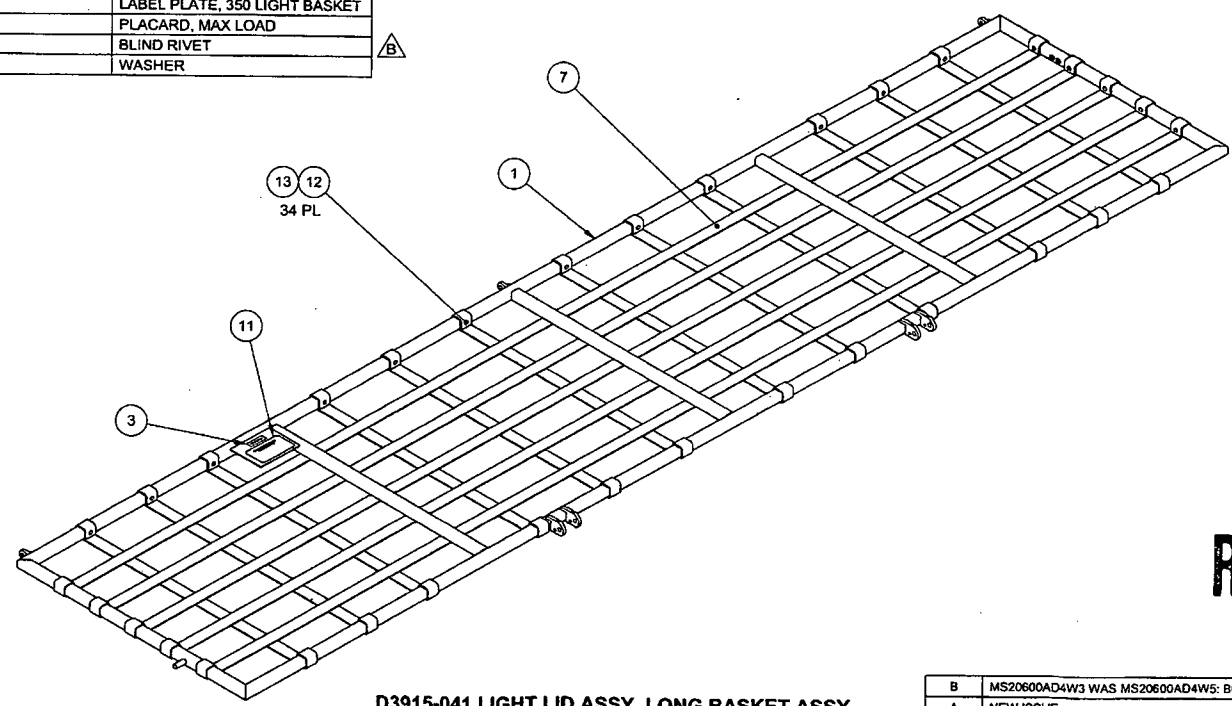
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#58326

RELEASED  
2010-04-16

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W3	BLIND RIVET
13	34		NAS1149DN416J	WASHER



**D3915-041 LIGHT LID ASSY, LONG BASKET ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 6.91 lbs

B	MS20600AD4W3 WAS MS20600AD4W5: BOM 8 (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED		D3915	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		LIGHT LID ASSY-LONG BASKET	Nts
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

# Dart Aerospace Ltd

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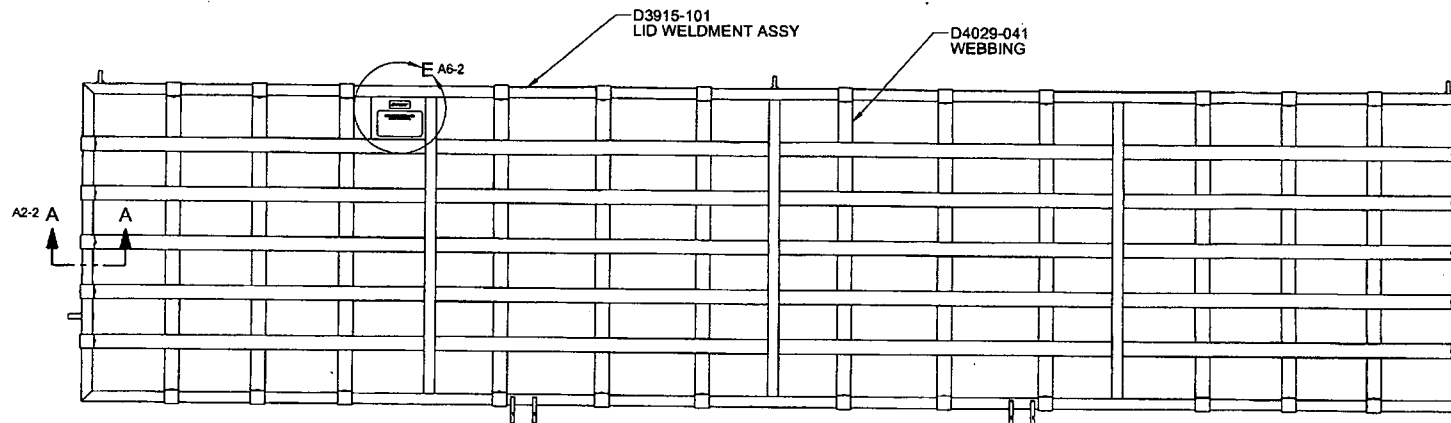
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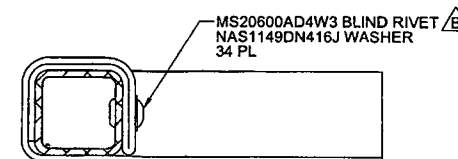
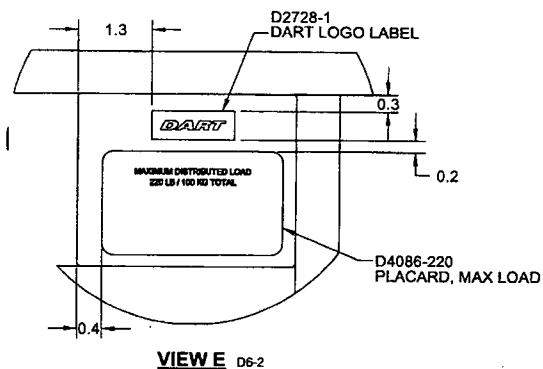
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**NOTE:** Date & initial all entries

#58306



**D3915-041 LIGHT LID ASSY, LONG BASKET**



**SECTION A-A C8-2**

**RELEASED**  
2010-04-14

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	Nts
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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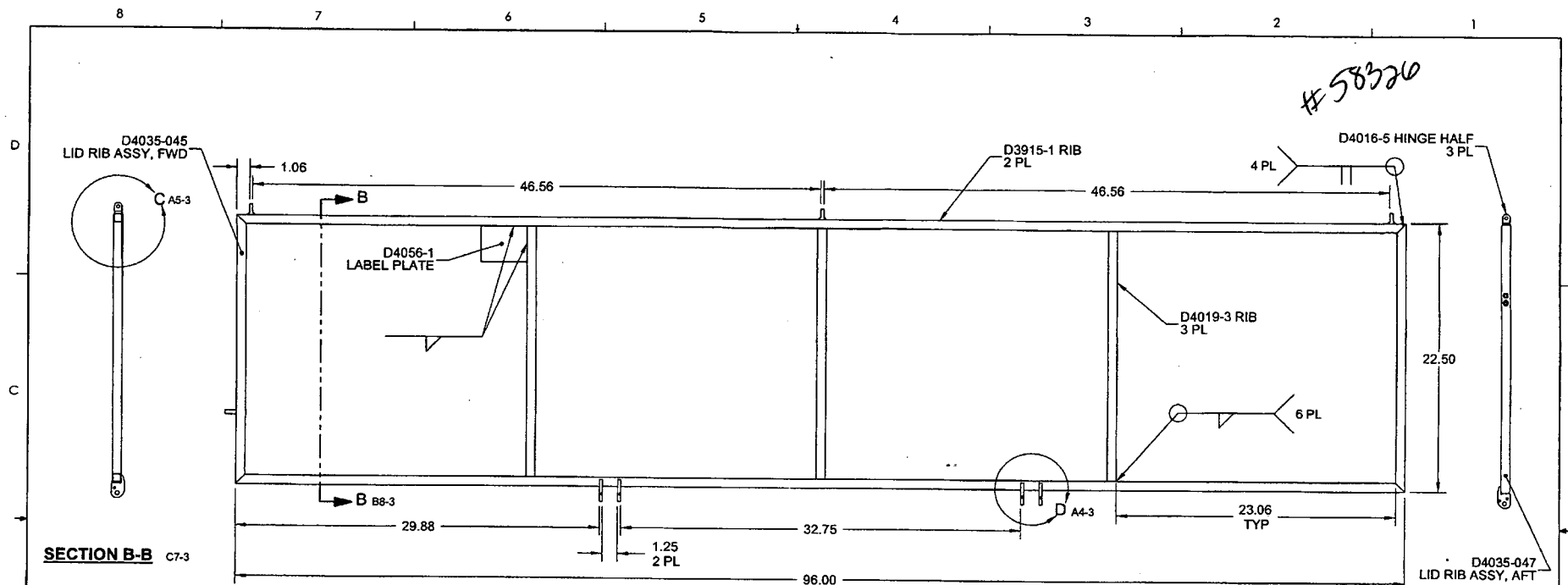
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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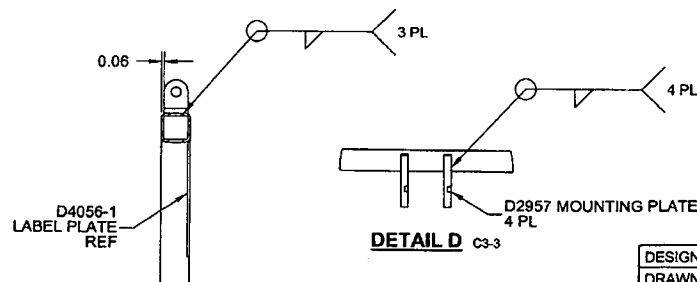
**NOTE:** Date & initial all entries

#58320



**SECTION B-B** C7-3

**D3915-101 BASKET LID WELDMENT ASSY ASSY**



**DETAIL C** D8-3

**DETAIL D** C3-3

**RELEASED**  
2010-04-14  
MD

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 4.81 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3915	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKE INTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

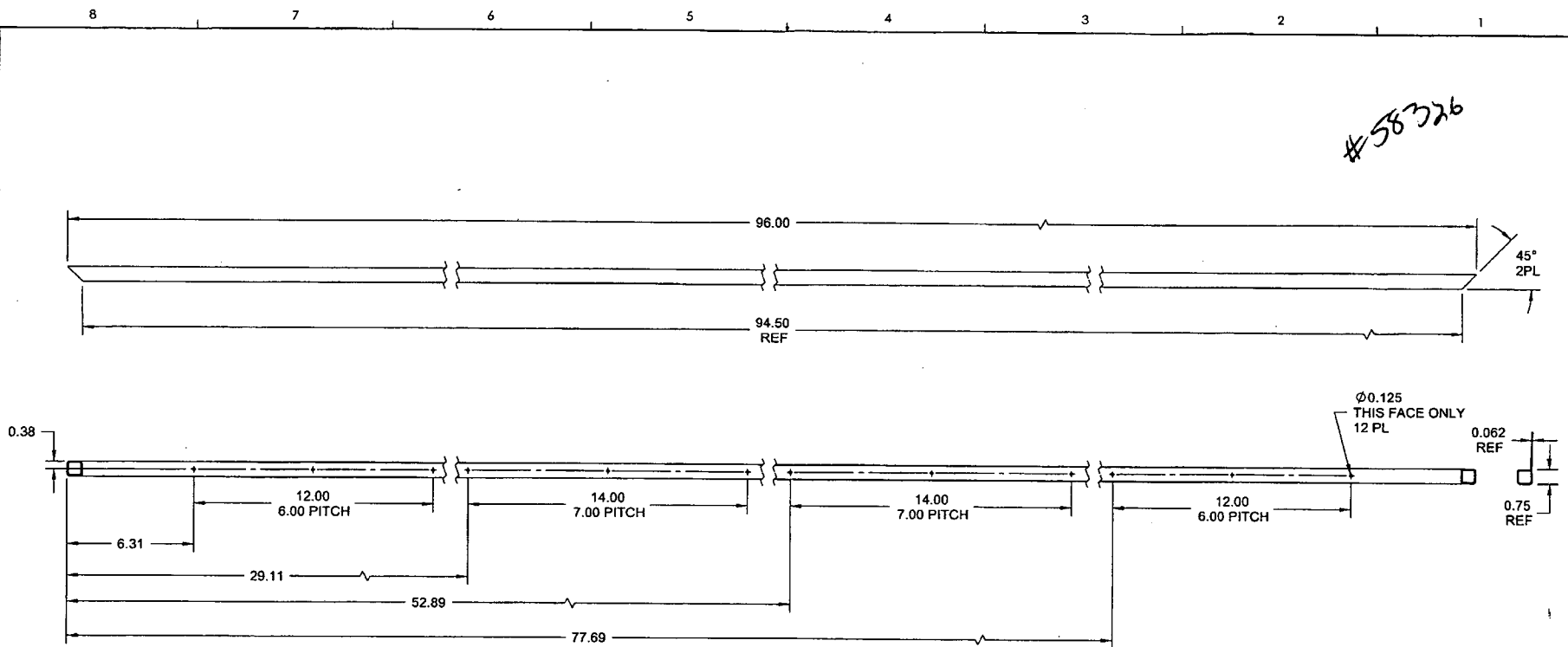
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#58326



**D3915-1 RIB**

**RELEASED**  
2010-04-14

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.49 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKETNTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

# Dart Aerospace Ltd

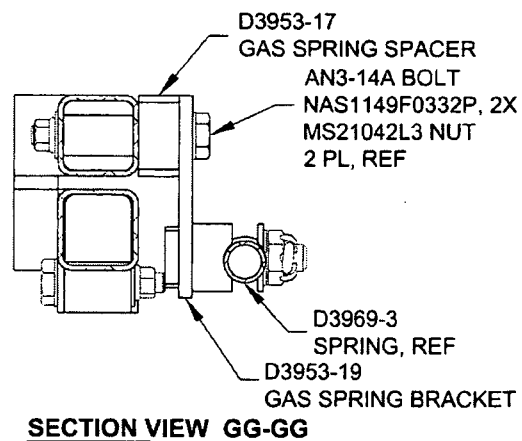
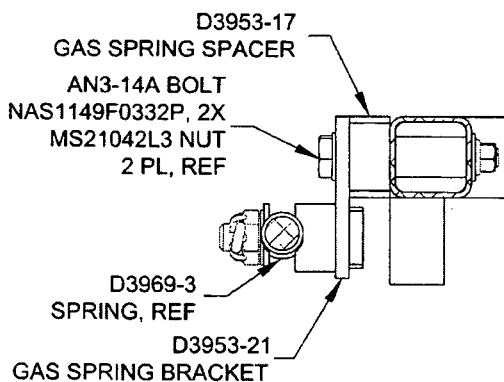
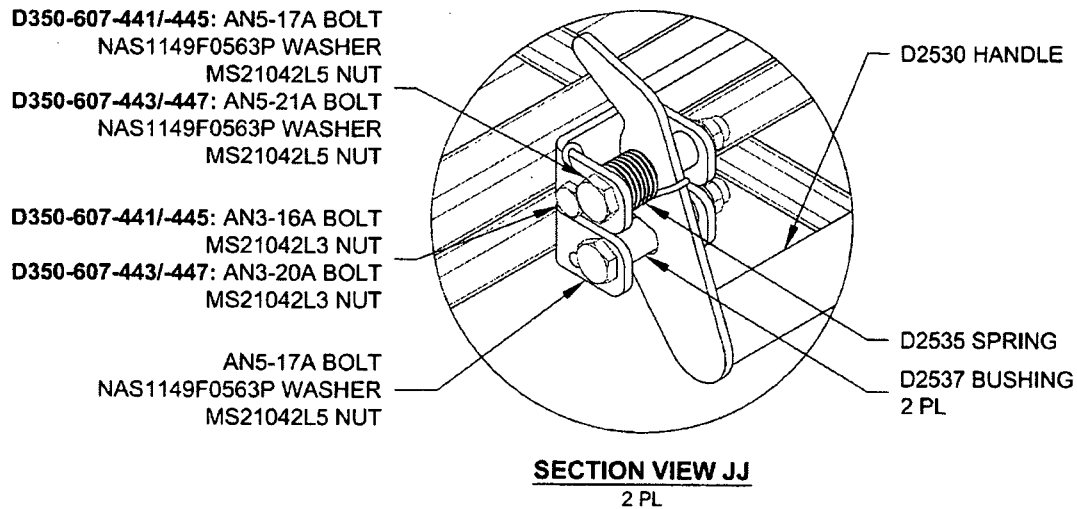
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**FIGURE 25-12a: D2530 HANDLE & D3969-3 SPRING INSTALLATION DETAILS**  
DETAIL VIEWS FROM FIGURES 25-9 AND 25-12b

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**25-00-00**